



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2893-1
Job Sheet 192456



Part No: D2893-1

Job Qty: 8 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/25/19

Job Tracking No:

Due Date: 3/29/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15 add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	8 pcs	3/29/19		0.33	15.69	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 8	8 pcs	3/29/19		0.00	0.00	QC 8 - 12		11/1 2019/03/30
							QC 8 - 14		19/03/31
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
130	Crosstubes - 2 - B4B	8 pcs	3/29/19		0.00	1.33	QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							Crosstubes - 1 - B4B		
							Crosstubes - 2 - B4B		



Container No: S167970



Part: D2893-1

Job No: 192456

Serial No/Batch: S167970

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/31/19

140 QC 3	8 pcs	3/29/19	0.00 0.00	Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	RD 19-4-2
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	APR 03 2019
				QC 3 - 19	DAS 40 9-89
170 Packaging 3-1 - Stock - B4B	8 pcs	3/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	LGSD APR 04 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	8 pcs	3/29/19	0.00 0.00	QC 21 - SA - 21	246 21
				QC 21 - SA - 70	APR 04 2019

Part Op **100** - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA081
 Descriptions: **120** - (QC8- Inspect parts - second check)
130 - (Crosstubes) Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. **5132100**
140 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____) LOCATION : LG050
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK078	D2893-1 Turning Detail	4 pcs (.5 ea)	100-HAAS 4 Axis	5167085

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK078	4	6	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

DART AEROSPACE LTD		Work Order:	192456
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.995	2.995	2.994	2.995	2.994
AB	0.440	0.460		0.450	0.450	.455	.455	.454
AC	0.125	0.160		0.160	0.160	.160	.160	.160
AD	0.040	0.060		0.050	0.050	.044	.044	.046
AE	0.188	0.193		0.188	0.188	.188 Ø	.188 Ø	.188 Ø
AF	0.125	0.160		0.137	0.137	.137	.137	.137
AG	0.140	0.160		0.150	0.150	.150	.151	.151
AH	1.360	1.400		1.375	1.375	1.375	1.375	1.375
AI	0.040	0.060		0.050	0.050	.051	.051	.051
AJ	1.190	1.230		1.215	1.215	1.217	1.216	1.217
AK	0.010	0.020		0.010	0.010	.010	.010	.010
AL	0.053	0.073		0.0625	0.0625	.063 R	.063 R	.063 R
AM	0.240	0.260		0.250	0.250	.250 R	.250 R	.250 R
AN	2.518	2.538		2.528	2.528	2.536	2.536	2.536
AO	84.39	90.39		87.39	87.39	87.00	87.03	87.00
AP	0.261	0.266		0.261	0.261	.261 Ø	.261 Ø	.261 Ø
AQ	0.053	0.073		0.0625	0.0625	.063 R	.063 R	.063 R
AR								
AS								
AT								
Accept/Reject								

Measured by: <i>VF</i>	Date: 2019-03-29
Audited by: <i>amk</i>	Date: 19/03/31
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	<i>[Signature]</i>

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FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6 1	7 2	8 3	9 4	10 5
HAAS Section								
AA	2.985	3.005		2.995	2.995	2.995	2.994	2.995
AB	0.440	0.460		.451	.453	.453	.450	.451
AC	0.125	0.160		.160	.160	.160	.160	.160
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.137	.139	.140	.138	.139
AG	0.140	0.160		.150	.150	.150	.150	.150
AH	1.360	1.400		1.375	1.374	1.379	1.377	1.376
AI	0.040	0.060		.049	.050	.050	.049	.049
AJ	1.190	1.230		1.216	1.217	1.218	1.215	1.216
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063 R	.063 R	.063 R	.063 R	.063 R
AM	0.240	0.260		.250 R	.250 R	.250 R	.250 R	.250 R
AN	2.518	2.538		2.538	2.537	2.537	2.538	2.538
AO	84.39	90.39		87.00	87.00	87.00	87.00	87.00
AP	0.261	0.266		.261 Ø	.261 Ø	.261 Ø	.261 Ø	.261 Ø
AQ	0.053	0.073		.063 R	.063 R	.063 R	.063 R	.063 R
AR								
AS								
AT								
Accept/Reject								

Measured by:	mm.	Date:	2019/03/30
Audited by:	mk	Date:	19/03/31
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
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HAAS Section								
AA	2.985	3.005		2.994	2.994			
AB	0.440	0.460		.450	.450			
AC	0.125	0.160		.160	.160			
AD	0.040	0.060		.050	.050			
AE	0.188	0.193		.188 ϕ	.188 ϕ			
AF	0.125	0.160		.137	.138			
AG	0.140	0.160		.148	.149			
AH	1.360	1.400		1.376	1.377			
AI	0.040	0.060		.049	.050			
AJ	1.190	1.230		1.217	1.217			
AK	0.010	0.020		.010	.010			
AL	0.053	0.073		.062 R	.062 R			
AM	0.240	0.260		.250 R	.250 R			
AN	2.518	2.538		2.538	2.538			
AO	84.39	90.39		87.00°	87.00°			
AP	0.261	0.266		.261 ϕ	.261 ϕ			
AQ	0.053	0.073		.062 R	.062 R			
AR								
AS								
AT								
Accept/Reject								

Measured by: M.M. **Date:** 20/9/03/31

Audited by: **Date:**

Preliminary Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
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